

Date: Thursday, 02/04/2009 2:28:46 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 46884	
Estimate Number : 12720	
P.O. Number :	Part Number : D353623
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44646	Material :
Written By :	Due Date : 10/04/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09.04.03</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 1.5220 sf(s)/Unit Total : 18.2645 sf(s)

NEOPRENE SHEET 0.063

Batch: 11015 1B 9-4-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A

Prog Rev: A

1B 9-4-14



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 9-4-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

809/04/15 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FLM 100

A 09/04/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 46884

Part Number: D353623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/15
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46884
Description: Gasket		Part Number: D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	X			
48.20	+/-0.030	48.20	✓			
44.70	+/-0.030	44.70	X			
39.31	+/-0.030	39.31	X			
33.92	+/-0.030	33.92	X			
28.53	+/-0.030	28.53	X			
23.14	+/-0.030	23.14	X			
17.75	+/-0.030	17.75	X			
14.25	+/-0.030	14.25	X			
9.50	+/-0.030	9.50	X			
4.75	+/-0.030	4.75	X			
8.00	+/-0.030	8.00	X			
16.00	+/-0.030	16.00	X			
24.00	+/-0.030	24.00	X			
32.00	+/-0.030	32.00	X			
39.00	+/-0.030	39.00	X			
48.00	+/-0.030	48.00	X			
0.30	+/-0.030	0.306	X			
0.30	+/-0.030	0.306	X			
1.89	+/-0.030	1.879	X			
Ø0.19	+0.005/-0.001	0.191	X			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-4-14	Date: 09/04/15	Date:	N/A

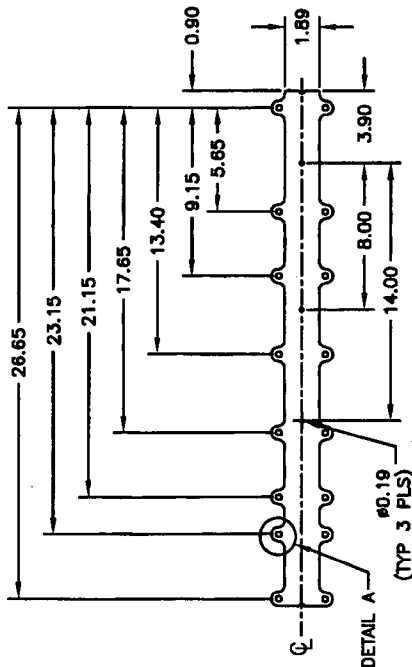
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

DART

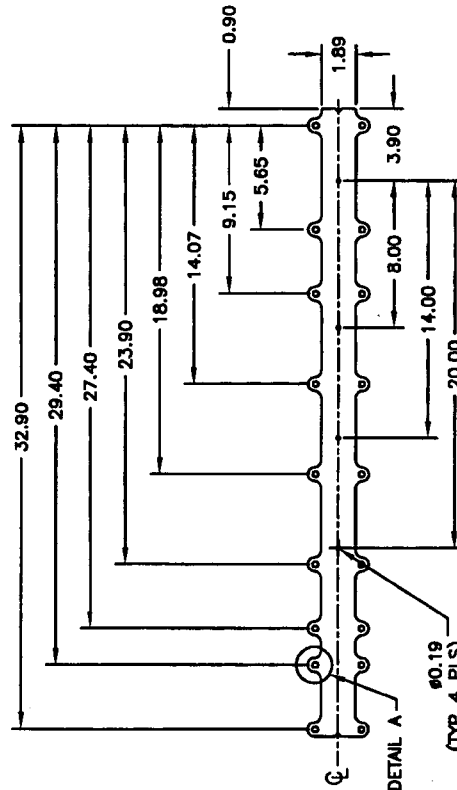
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CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

09.02.12



D3536-11 GASKET



D3536-13 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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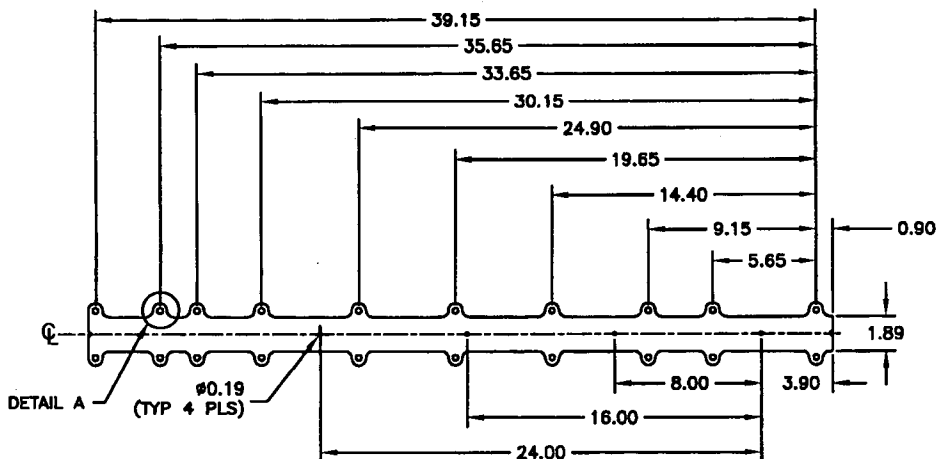
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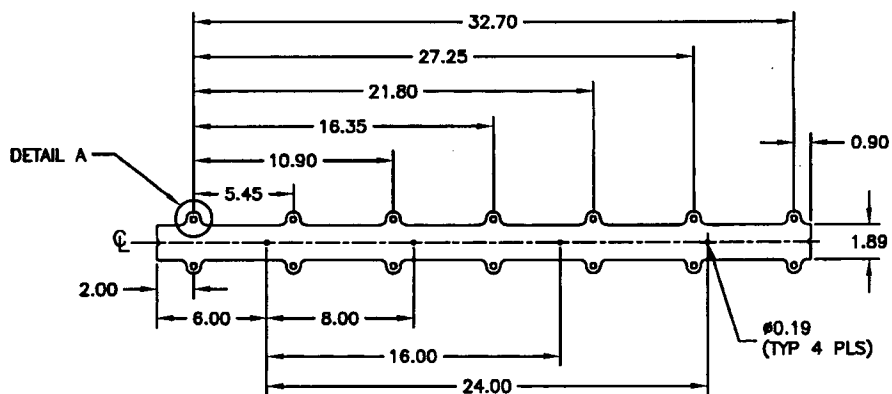
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		TITLE	GASKET	SHEET 2 OF 6
				SCALE 1:10

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D3536-15 GASKET



D3536-21 GASKET

NOTES

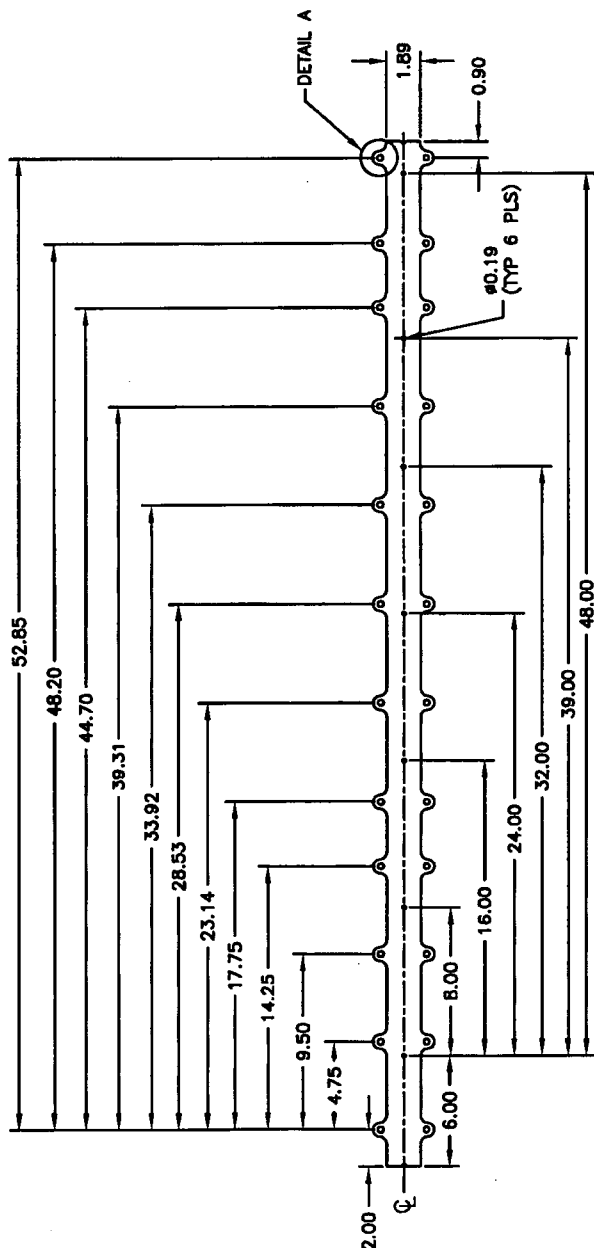
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- 2) FINISH: NONE
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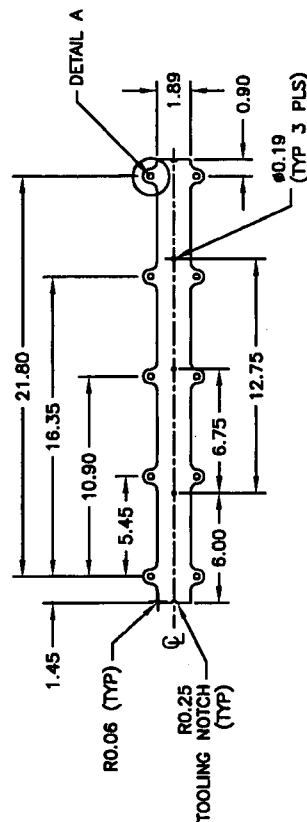
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DATE 06.10.25	TITLE GASKET		SCALE 1:10

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D3536-23 GASKET



D3536-25 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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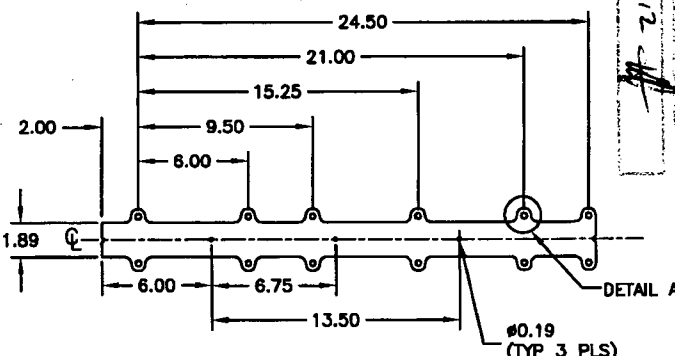
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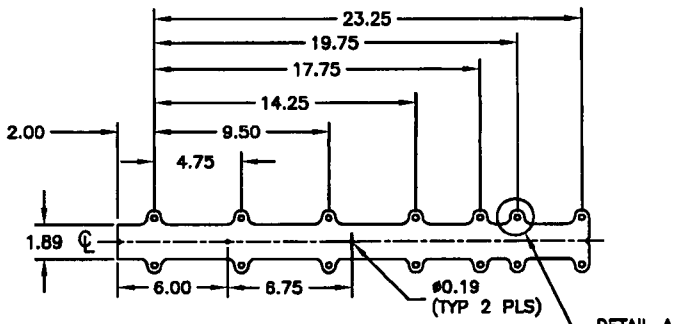
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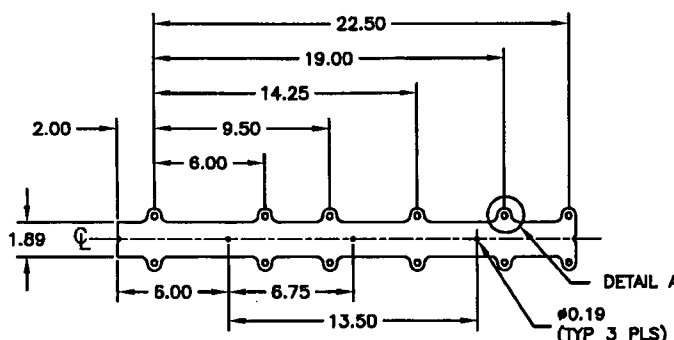
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

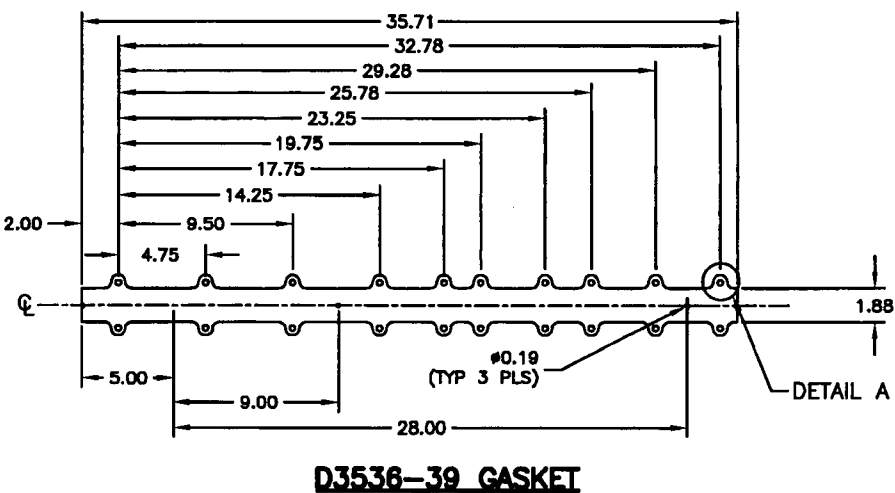
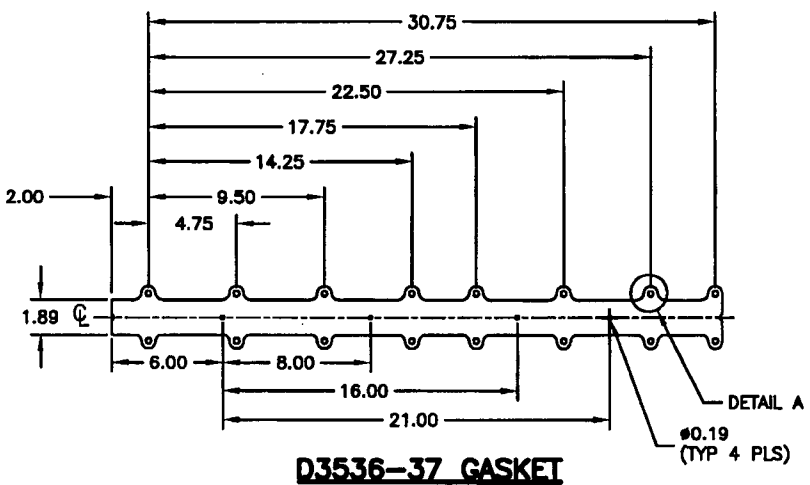
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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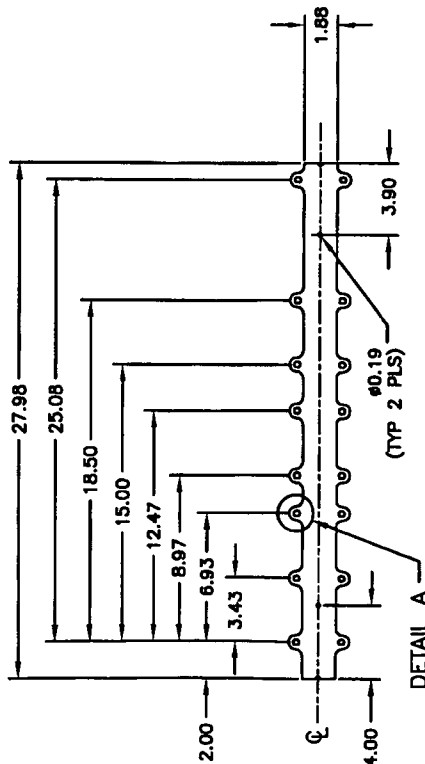
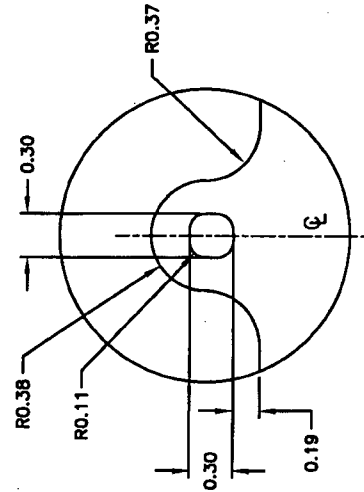
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DETAIL A**D3536-41 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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